

## ABSTRACT OF THE DISCLOSURE

A closed system and method that includes a source of pressurizeable molten lead connected to a mold having a mold cavity therein with the mold maintainable at sufficiently low temperature so that a charge of molten lead located in the mold cavity solidifies to thereby form a solidified casting in the mold cavity. A housing having a runner, is maintainable at sufficiently high temperature to maintain the molten lead in a molten state so that the mold cavity can be refilled with a fresh charge molten lead when a solidified casting is removed therefrom without introducing air to the closed system. A shut-off valve, having an open position to allow a charge of molten lead to flow into the mold cavity and a closed position to prevent molten lead from flowing out of the runner as the molten lead in mold cavity solidifies with the shut-off valve configurable to intensify the pressure of the lead in the mold cavity.